

SPLIT

Dart Aerospace Ltd.

Date: Thursday, 04/01/2007 11:07:52 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30155		
Estimate Number	: 10255		
P.O. Number	: <i>N/A</i>	Part Number	: D22301
This Issue	: 04/01/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 29377	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 30/01/2007 Qty: 300 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s)  
 Lug Extrusion D2423 Extrusion  
 Batch: *30062*

*RG 07.01.18**300*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut D2423 extrusion to 0.82"  
 Batch: *30062*

*RG 07.01.18**300*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2230-1  
 (Check for crack while loading into the machine.)  
 2-Tumble and deburr rough edges after tumbling

*Issue P.O. 2902**Machine per drawing D2230 Rev F**12/07/10/11/9 300*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Receive & Inspect for**transit damage**10/11/12 200*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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Drawing Name: MOUNTING LUG

Job Number: 30155

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

SECOND CHECK



Comment: SECOND CHECK

Inspect Level 5

07-02-23  
ASPCA

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M

07/02/23

(200)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m/07/02/23

(200)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

FL/

07/02/23

(200)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

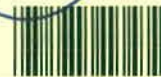
07/02/23 (201)

CU

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51370

07/02/26

CU

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/26

(200)

Job Completion



U 07-02-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

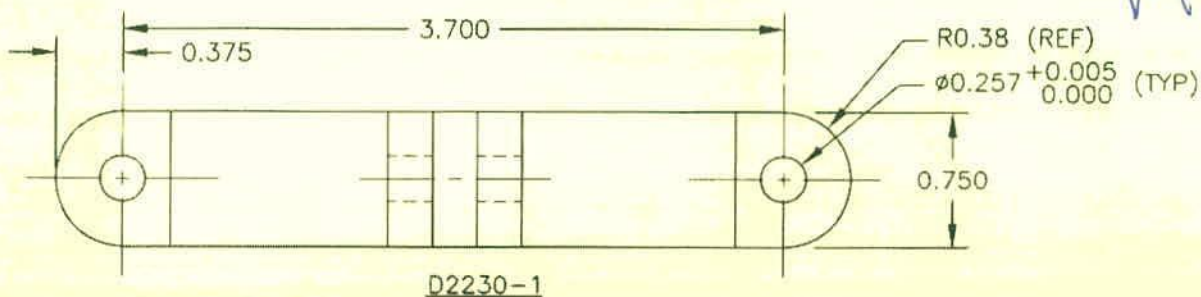
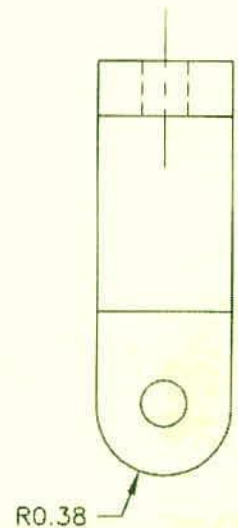
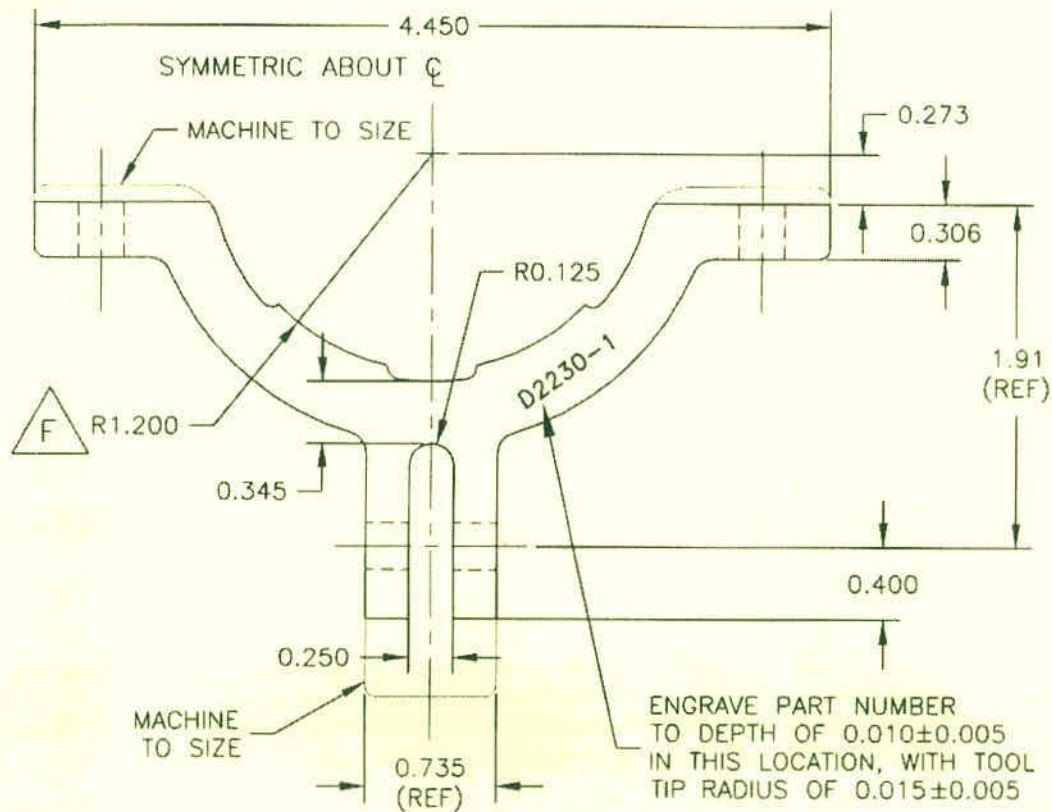
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 2
				D2230	
DATE	99.12.13			TITLE	SCALE
				MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

**RELEASED**  
99.12.21 DS

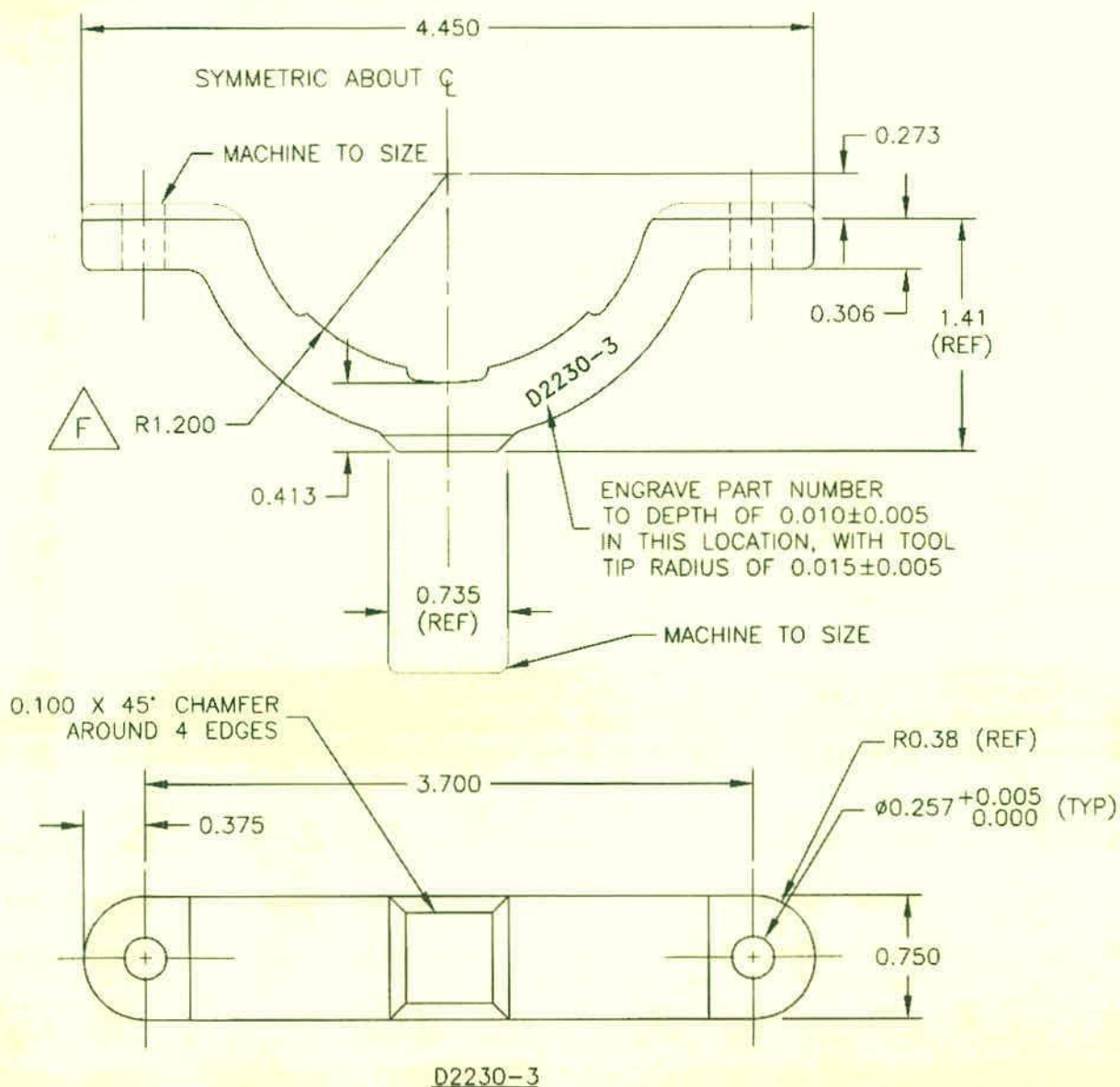
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
19 12 21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







### CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-1

Mounting Lug B30165

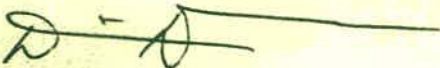
2902

MATERIAL: supplied by DART D2324 B30062

2423

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Denise Robinson

Vankleek Hill, February 22, 2007



